

Amendments to the Specification:

Please replace the paragraph beginning on page 3, line 14 with the following rewritten paragraph:

-- The present invention is directed to overcoming one or more of the problems set forth above. Briefly summarized, a method of manufacturing a web-winding device includes the step of providing a generally cylindrical injection molded support structure having an outer web wrapping surface for receiving at least one convolution of a web and, an interior portion having an annular surface joined to the outer web wrapping surface, said outer web wrapping surface having a surface texture less than 0.5 microns Ra to produce a static coefficient of friction x_1 between the outer web wrapping surface and a first contact surface of said at least one convolution of web and a second contact surface of an at least a partial second convolution of said web produces a static coefficient of friction x_2 , wherein x_1 is less greater than x_2 . --